

Work Order ID 55160

January 7, 2010 1:32:55 PM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10-1-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

S 10/02/09

[Signature] for LL 10/02/09

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M111311*
M111494

3-Grind End Plate flush

10-01-27

10 / 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 07/01/2011 Start Qty: 5.00



Cust ID:

Required Date: 10/02/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120 QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

x5

BE 10/01/28

130 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ S 10/01/28

x5/KH

140 Chemical Conversion Cont. per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

PH 10-01-28

5 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAD

5/10

Quality Control

10-02-01

180

Large Fab

0.00



Large Fab

Memo

0.00

5

dp

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☒ M111311

6-Grind End Plate flush

7-Install last rivet as per Dwg

pk 10-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Revision ID:

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Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010 Start Qty: 5.000

Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 5.000

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00							PD 10.02.02
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							27 S10102102
210 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							27 M 10102104

+5
RHC

RSR 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55160

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Item ID: D350-594-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 07/31/2010 Start Qty: 5.00

Cost Item

Required Date: 10/02/2010 Req'd Qty: 5.00

Customer

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME: 9:15AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:45AM

0.00

⇒ M 10/02/05

XSAH

Ø

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

M 112900

bf 10-02-8

5RH/9

0.00

240

QC3- Inspect Part Finish

0.00



QC

Memo

8/10/02/09

8/10/02/09

+5

RH

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55160

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Item ID: D350-591-312

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Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-2-8

260

QC4- 100% inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Solder

45
RM

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: _____

Rev B

10-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55160

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Stop, Long RH

Start Date: 07/01/2010 Start Qty: 5.00

Cost Item ID:

Required Date: 10/02/2010 Req Qty: 5.00

Customer:

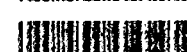
Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/09 *[Signature]*
MF
10-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

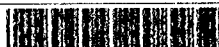
Picklist Print

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Page 1

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Work Order ID: 55160



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04-03-22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3572-1 JLM

IPP Rev: C 08-04-02 ECN1163 DD verified by: EC

IPP Rev: D 08-04-08 ECN1164 DD verified by: cC

D3065-041

Manufactured No

Each

60.0000

5.0000



Step Leg Assembly Hi

10.02.02

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

53523

14

Main Warehouse

WA

46

52104

6

53795

40

5

D3066-1

Manufactured No

Each

102.0000

10.0000



Spacer

10.02.02

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

102

51545

11

53783

91

10

D3219-1

Manufactured No

Each

122.0000

10.0000



Plate

10.01.27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

122

53789

122

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55160



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04.03.22 New issue K/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3572-1 JLM
 IPP Rev: C 08-04-02 ECN1163 DD verified EC
 IPP Rev: D 08-04-08 ECN1164 DD verified EC

D3067-1 Manufactured No 110 Each 113.0000 5.0000



End Plate

10.01.27

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

113

53784

113

5

D3272-1 Manufactured No 110 Each 0.0000 5.0000



Step

MS21042L5

72

Purchased No

110 Each

1,005.000 10.0000



Nut

10.01.12 B55158

10-2-8

SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1005

110382

10

111636

11

112314

484

113523

300

113537

200

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55160

Parent Item: D350-591-342

Parent Item Name: Heli-Access-Step, Long RH

Comments: IPP Rev: A ☐ 08-05-22 ☐ New Issue ☐ KJ/RF ☐

IPP Rev: B 07-06-09 ☐ D3572-1 JLM

IPP Rev: C 08-04-02 ☐ E N1163 DD verified by: EC

IPP Rev: D 08-04-08 ☐ E N1164 DD verified by: EC

Start Date: 07/01/2010

Required Date: 10/02/2010

Start Qty: 5.00

Required Qty: 5.00

MS20600-AD4W4

Purchased

No

180

Each

1,683.000 80.0000



Rivets

10.02.02

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1683

110731

215

111359

46

111477

74

112314

824

112385

24

113368

500

80

AN3-35A

x2

Purchased

No

260

Each

261.0000 10.0000



Bolt

10-2-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

261

106993

12

110467

1

112314

248

10

January 7, 2010 1:33:01 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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January 7, 2010 1:33:01 PM

Work Order ID: 55160

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments:

IP Rev: A 04.03.22 New issue K1/R

Start Qty: 5.00

Required Qty: 5.00

IP Rev: B 07-06-09 Added D3572-1 JLM

IP Rev: C 08-04-02 ECN1163 DD verified by: EC

IP Rev: D 08-04-08 ECN1164 DD verified by: eC

AN4-13A

76

Purchased

No

260

Each

569.0000

40.0000



Bolt

10-2-5

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

569

413359

569

17406

0

51764

0

40

AN5-36A

72

Purchased

No

260

Each

175.0000

10.0000



Bolt

10-2-5

(5x)

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

175

109545

11

110467

7

110731

4

112243

20

112314

83

112385

50

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04.03.22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3572-1 JLM

IPP Rev: C 08-04-02 ECN1163 DD verified by: EC

IPP Rev: D 08-04-08 ECN1164 DD verified by: EC

AN960JD10

Purchased

No

260

Each

998.0000

20.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

998

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

78

112369

22

113149

608

141132 88 10-2-5

(EY) SD

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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January 7, 2010 1:33:01 PM

Work Order ID: 55160

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long Rfl

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04-03-22 New issue 01/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added 03572-1

IPP Rev: C 08-04-02 BCN1163 DD Verified by: EC

IPP Rev: D 08-04-08 BCN1164 DD Verified by: cC

AN960JD416

Purchased

No

260

Each

1,489.000 80.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1489

103691

20

104215

6

108161

329

110523

340

111279

101

111916

482

112314

211

16941

0

M113524 10-2-5 SP

AN960JD516

Purchased

No

260

Each

589.0000 20.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

589

110363

46

110523

57

111279

39

112082

64

112314

14

112828

18

113149

351

M113288 10-2-5 (SP) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 55160

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A ☐ 04.03.22 ☐ New issue ☐ KJ/RF ☐

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3572-1 JLM

IPP Rev: C 08-04-02 ECN1163 DD verified by: EC

IPP Rev: D 08-04-08 ECN1164 DD verified by: eC

D2230-3 Manufactured No

260

Each

177.0000

20.0000



Lug

16-2-5 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

50306

5

51568

2

Main Warehouse

ST176

100

53881

100

Main Warehouse

ST476

70

53781

70

16-2-5 sf

D2618 Manufactured No

260

Each

121.0000

10.0000



Bushing

16-2-5 sf (56)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST39

121

50989

121

10

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

January 7, 2010 1:33:01 PM

Work Order ID: 55160



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04.03.22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3572-1 JLM

IPP Rev: C 08-04-02 ECN1163 DD verified by JLM

IPP Rev: D 08-04-08 ECN1164 DD verified by JLM

D2856-400 220 770" Manufactured No 260 f 290.3921 3.0000



Abraison Strip

↳ MURDER

10-2-5

54

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

290.3920842

50593

141.312084

52563

149.08

3

D3067-1 Manufactured No 260 Each 113.0000 5.0000



End Plate

10.02.02

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

113

53784

113

5

D3235-1 Manufactured No 260 Each 35.0000 10.0000



Mounting Lug

1354756 (8x) 10-2-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

45398

4

53785

31

January 7, 2010 1:33:01 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

January 7, 2010 1:33:01 PM

Work Order ID: 55160

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04-03-22 New is: KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Add: 23572-1 JLM

IPP Rev: C 08-04-02 ECN 53 DD verified by: EC

IPP Rev: D 08-04-08 ECN 64 DD verified by: cC

D3278-041  Manufactured No 260 Each 53.0000 5.0000

Support Assembly

10-2-5

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53


52075

13

53227

49

5

MS21042L3  x2

Purchased

No

260

Each

2,916.000 10.0000

10-2-5

SP
(54)

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2916

110844

35

111274

27

111668

52

112314

1302

112385

500

113523

300

113537

700

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

January 7, 2010 1:33:01 PM

Work Order ID: 55160



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: 04.03.22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: 07-06-09 Added D3572-1 JLM

IPP Rev: 08-04-02 ECN1163 DD verified by:EC

IPP Rev: 08-04-08 ECN1164 DD verified by:cC

MS21042L4

Purchased

No

260

Each

4,009.000 40.0000



Nut



10-2-5

54

Warehouse

Loc Qty

Unit Code

Location

Main Warehouse

ST

4009

102552

6

104248

6

110507

184

111827

2813

113422

1000

15924

0

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN Q2	DRAWN B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3272	REV. 0 SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NFS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.18



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	M520600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55160
BS 10-1-07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

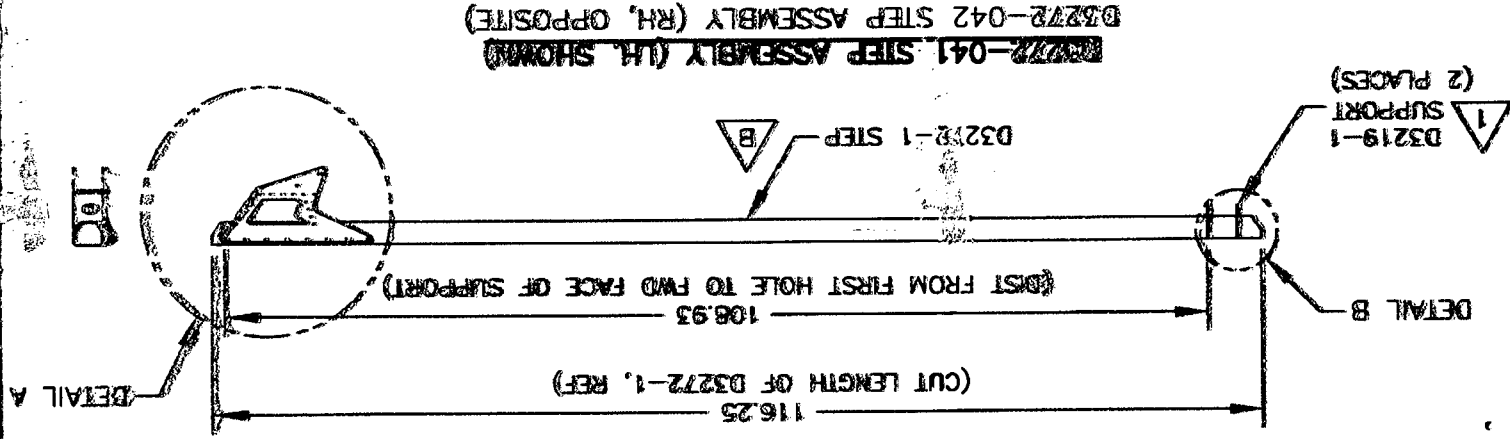
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

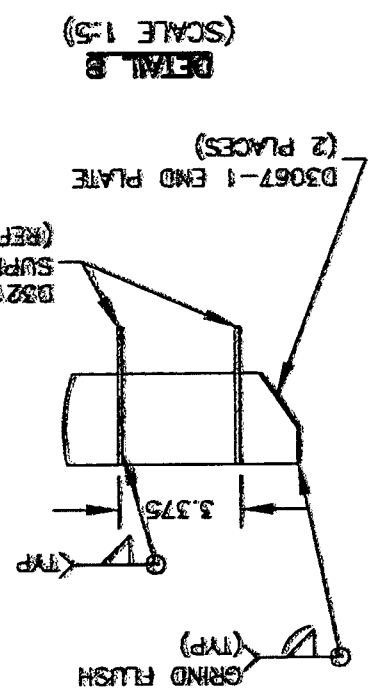
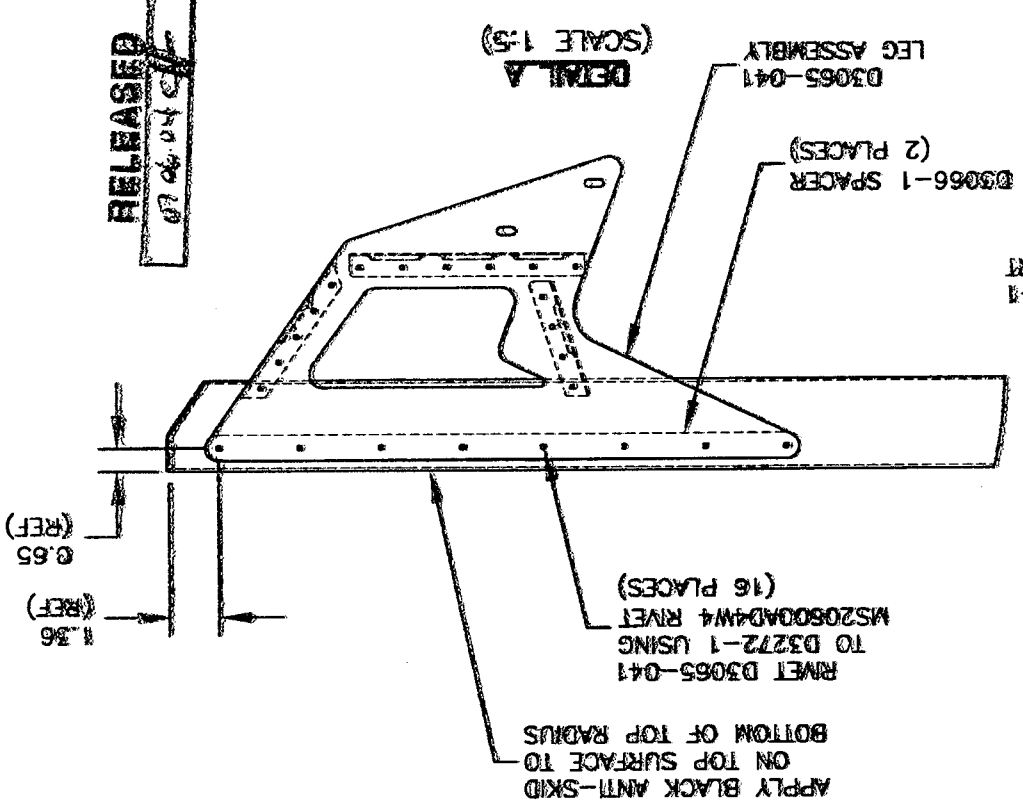
DART

WIP 55160

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	MARKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. B
		D3272	SHEET 2 OF 3
DATE	TITLE		SCALE
07.05.18	STEP ASSEMBLY, HI LONG		1:20



D3272-041 STEP ASSEMBLY (LH SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

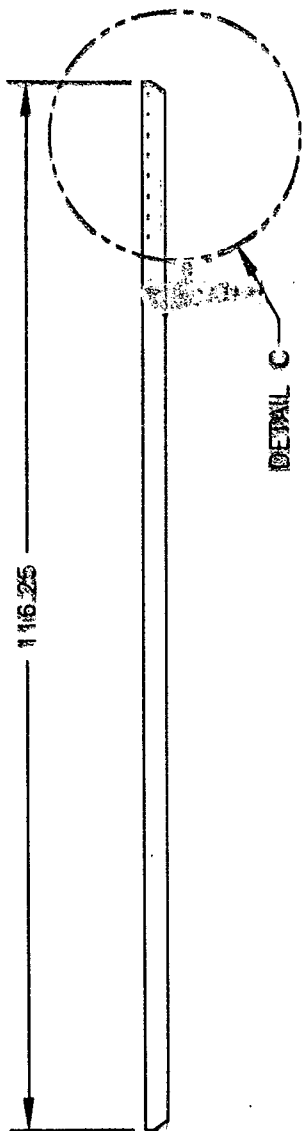
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. D SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

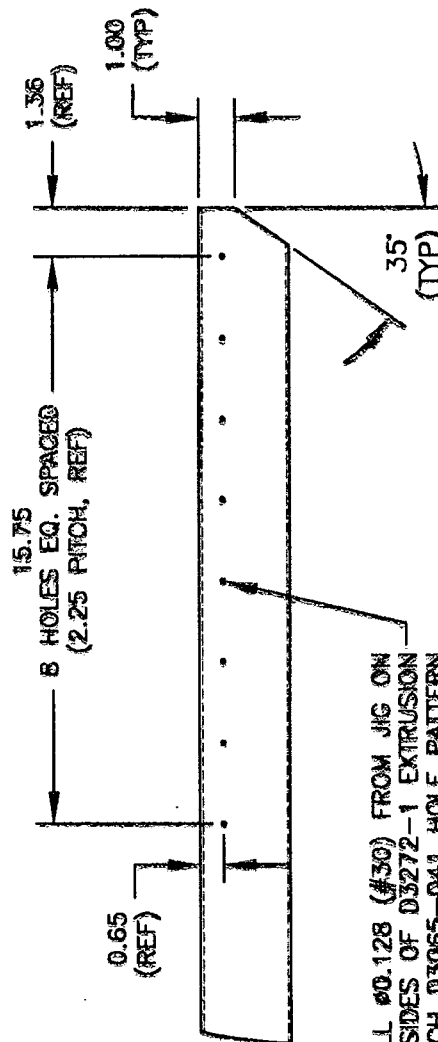
07.06.04



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL #0.128 (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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